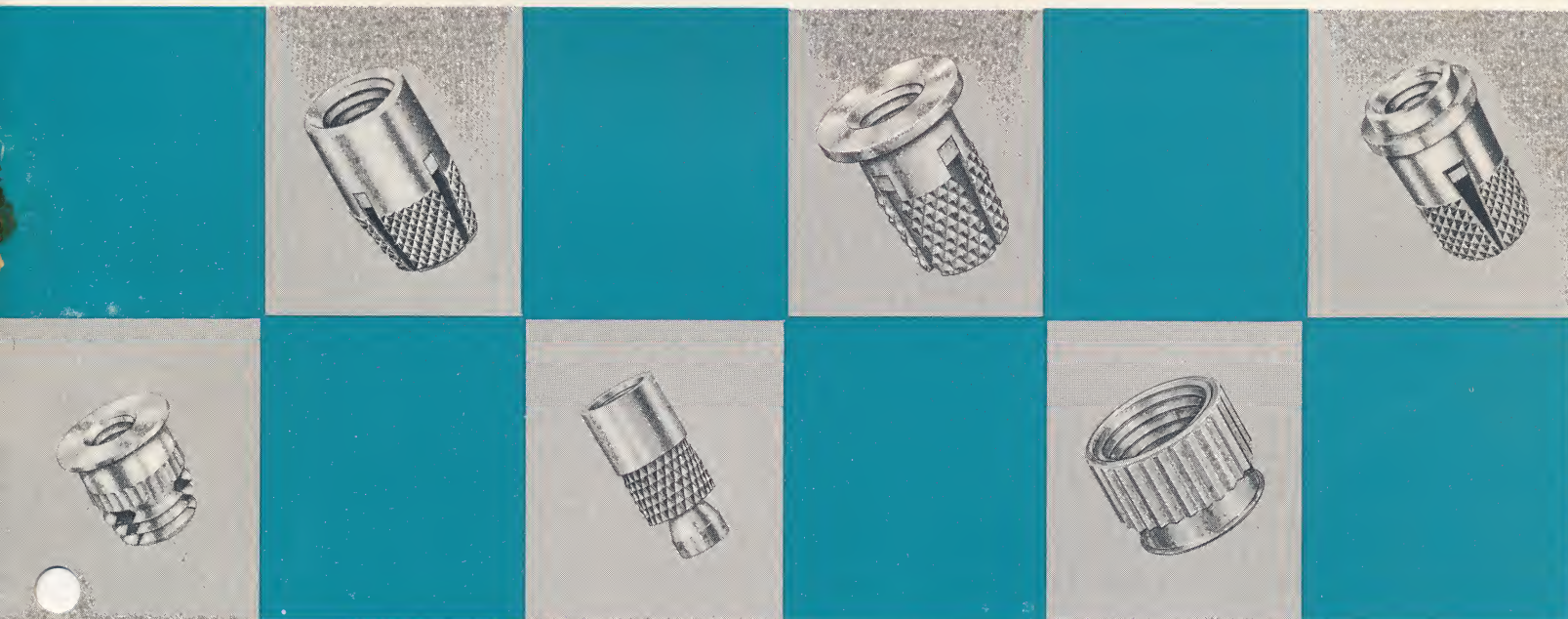


DODGE[®] EXPANSION INSERTS

- STRONG THREADS IN PLASTICS AFTER MOLDING
- STRONG THREADS IN WOOD PRODUCTS



©Reg. U.S. Pat. Off.



PHELPS DIVISION
HELI-COIL CORPORATION
SHELTER ROCK LANE, DANBURY, CONNECTICUT 06810

Save time and money with DODGE®

Expansion Inserts installed after molding

Everyone Profits

With DODGE Expansion Inserts

Higher profits are being realized by leading original equipment manufacturers and custom molders. They now install DODGE Expansion Inserts **after** molding. Molding in inserts or tapping threads directly into the parent material are costly methods that can be eliminated.

PRODUCT DESIGNERS—DODGE Expansion Inserts offer design advantages not found in other type inserts. The exclusive DODGE spreader plate assures predictable insert expansion and locking force within the hole, permitting realization of full tensile and torque values of the mating screw.

CUSTOM MOLDERS—Since DODGE Expansion Inserts are installed **after** molding, they reduce open press time, thus increasing production cycles of available molding equipment. Operators no longer have to place inserts on pins within a **hot** mold cavity. Floating, cocked, crushed and

forgotten inserts are eliminated... along with rejected parts. And DODGE Inserts can be installed later by less skilled personnel.

MOLD MAKERS—Designs calling for DODGE Expansion Inserts permit simpler, less costly mold construction. Your recommendation to the custom molder to use DODGE Inserts can bring about the savings which will get him the job instead of his competition.

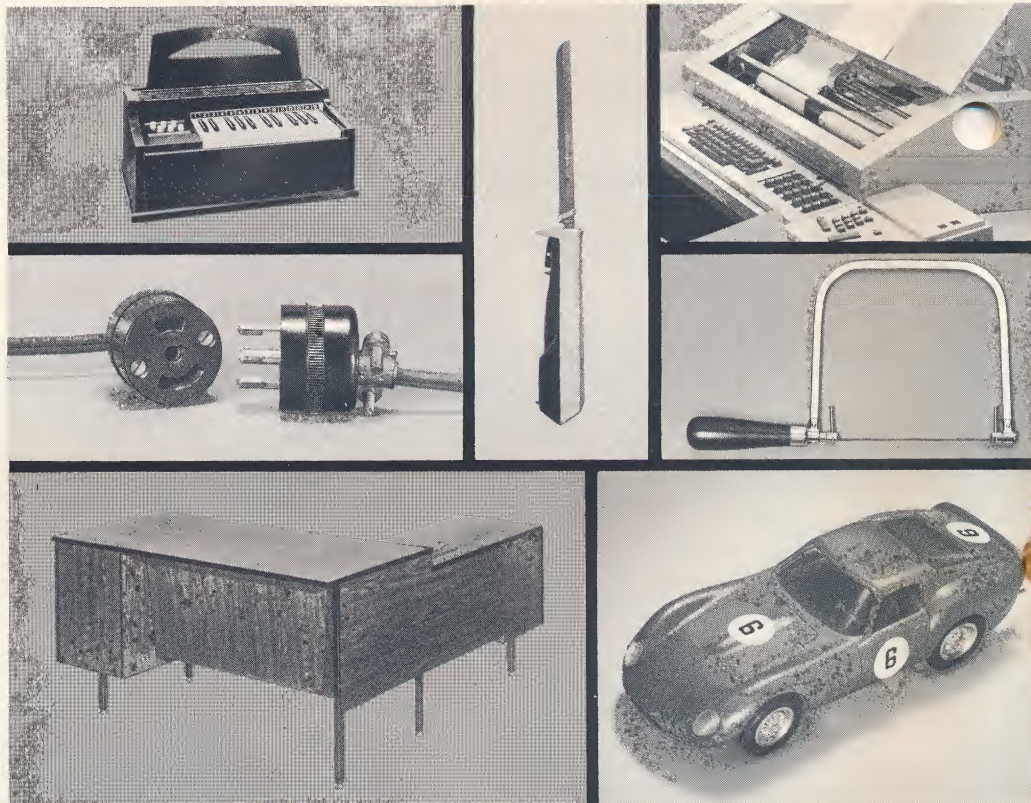
PURCHASING AGENTS—The savings assured by DODGE Inserts, as compared to the added costs of molded-in inserts, requiring more open press time, make the difference between a highly priced or a competitively priced product.

PRODUCTION MANAGERS—DODGE Inserts are installed in far less time than is required to drill and tap screw threads in plastics. DODGE automatic feeding and anchoring machines permit installation of up to 40 inserts a minute for volume production.

TABLE OF CONTENTS

	Page
<i>Insert Types</i>	
Expansion Inserts	
Expansion Principle.....	2
Standard Insert.....	3
Clinch Insert.....	3
Flange Insert.....	4
Wedge Insert.....	5
Cone-Spread Insert.....	4
Cone-Spread Principle.....	4
Flo-Lock Bushing.....	5
<i>Installation Information</i>	
Hole Size and Condition.....	6
Installation Methods.....	6
Strength.....	6
<i>Installation Tooling</i>	
Automatic Installation Machine.....	7
Hand Tools.....	7
Semi-automatic Tools—Standard.....	7
Semi-automatic Tools—Clinch.....	7
Purchasing and Leasing Plan (Machine)...	7
Engineering Assistance.....	7
<i>Specials</i>	
Materials.....	7
Engineering Modifications.....	7
Ordering Information.....	7

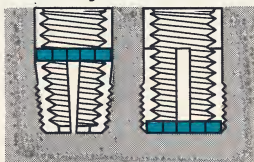
TYPICAL APPLICATIONS



How the DODGE "Expansion Principle" Works...

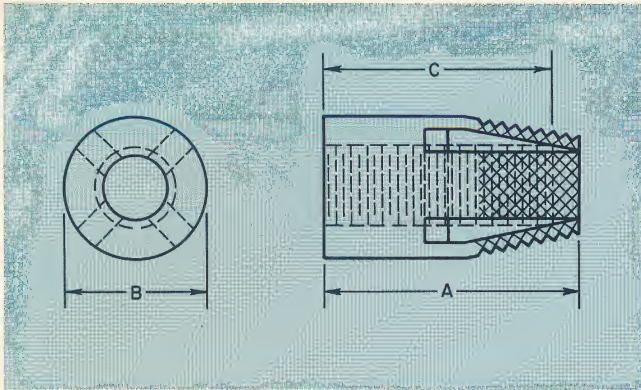
The DODGE Expansion Insert is a two-piece unit, consisting of an internally threaded brass shield with four slots and a four-eared

spreader, captive within the shield, which anchors the knurled shield in a hole.



1. **After** molding, the DODGE Insert is placed in a cored hole. The spreader is forced downward. The spreader ears, working against the walls of the slots of the shield, expand the insert without contacting the threads.
2. Fully depressed, the spreader firmly anchors the knurled shield in the hole.

INSERT TYPES



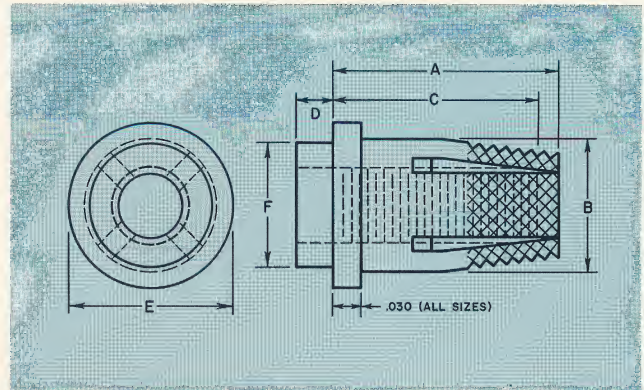
STANDARD INSERT

The Standard Insert is used widely to provide strong brass threads in plastic parts of all types **after** molding. In addition to their use for conventional assembly techniques, Standard inserts can also be installed to protrude, serving the dual purpose as an assembly-locating device. Highly versatile, Standard Inserts provide the answers for the majority of applications where long-life threads are required in plastic parts.

AVAILABLE SIZES AND DIMENSIONS				
		A	B	C
SIZE	PART NO.	Installed Length	Body Diameter	Threaded Length
4-40	70015-04	.250	.156	.188
5-40	70015-05	.313	.188	.250
6-32	70015-06	.313	.188	.250
6-32	70015-06	.375	.188	.313
8-32	70015-2	.313	.219	.250
8-32	70015-2	.375	.219	.313
10-24	70015-3	.375	.250	.313
10-24	70015-3	.438	.250	.375
10-32	70011-3	.313	.250	.250
10-32	70011-3	.375	.250	.313
10-32	70011-3	.438	.250	.375
1/4-20	70015-4	.500	.313	.438

How to Order: To order a 10-32 Dodge Insert by .375 assembled length, order Part No. 70011-3 x .375.

Four DODGE Standard Expansion Inserts are used to attach the floor panel to the organ housing.



CLINCH INSERT

The Clinch Insert, in addition to having all the features of the Standard Insert, features a pilot and a flange. The pilot may be clinched over a terminal, eyelet fashion, while the flange offers a broad surface for good electrical contact. Since the downward force of installation is absorbed by the flange, the Clinch Insert may be used in relatively thin-section applications. This insert is used extensively in the electric and electronic industries.

AVAILABLE SIZES AND DIMENSIONS						
		D	A	B	C	E
SIZE	PART NO.	Pilot Height	In-stalled Length	Body O.D.	Thread Length	Flange O.D.
4-40	70515-04	.040	.250	.156	.188	.219
4-40	70515-04	.064	.226	.156	.164	.219
6-32	70515-06	.040	.313	.188	.250	.250
6-32	70515-06	.064	.289	.188	.226	.250
8-32	70515-2	.040	.375	.219	.313	.281
8-32	70515-2	.064	.351	.219	.289	.281

How to Order: To order a 4-40 Clinch Insert with a pilot height of .040 and an assembled body length of .250, order Part No. 70515-04 x .040 x .250.

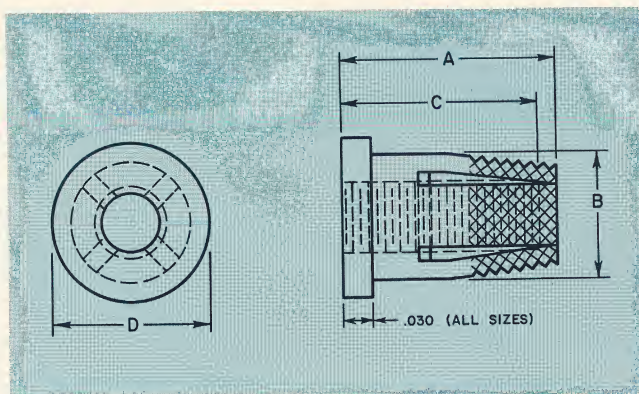
Pilot Height: The two pilot heights shown (Dimension D) are designed for use with terminals .020" thick. Variations in applications may necessitate different pilot heights or over-all lengths, which can be furnished on special order.

Additional Sizes:—DODGE Clinch Inserts can be manufactured to #10, 1/4" and 5/16" sizes to meet your requirements.

Two DODGE Clinch Inserts are used to retain armature, fan cover and brush sleeves in popular electric knife.



INSERT TYPES



FLANGE INSERT

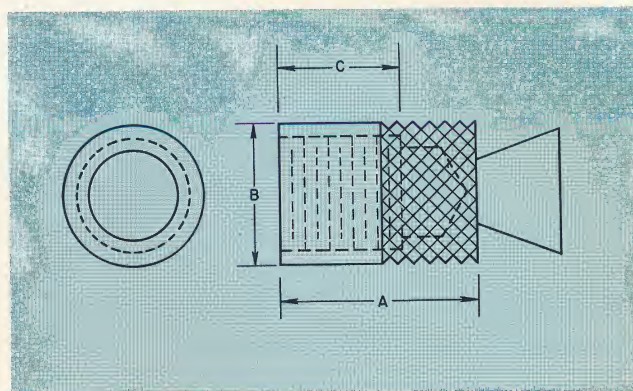
The Flange Insert features a flange with a large surface for effective electrical contact in addition to all of the design features of the Standard Insert. The flange may also be used to hold down mating parts. When used to permanently attach separate parts, the Flange Insert is placed through a hole in one part and into the cored hole in the parent material. When the insert is installed, it permanently affixes the added part. Other parts may be joined with a binding screw installed in the threads of the insert.

This insert is especially well suited for thin-section applications, since the downward force of installation is absorbed by the flange.

AVAILABLE SIZES AND DIMENSIONS					
		A	B	C	D
SIZE	PART NO.	Installed Length	Body Diameter	Threaded Length	Flange Diameter
4-40	70315-04	.219	.156	.156	.219
6-32	70315-06	.281	.188	.219	.250
8-32	70315-2	.281	.219	.219	.281
10-24	70315-3	.313	.250	.250	.313
10-32	70311-3	.313	.250	.250	.313
¼-20	70315-4	.438	.313	.359	.406

How to Order: To order a 6-32 Flange Insert by .281 over-all length, order Part No. 70315-06 x .281.

Three DODGE Flange Inserts provide reuseable threads and give added strength to thin-wall application in assembly posts of this slot car racer.



CONE-SPREAD INSERT

The Cone-Spread Insert is designed for use in miniaturized parts where #0 Size screws and larger are used. This one-piece brass insert utilizes the unique DODGE "Cone-Spread Principle" (see below) to anchor itself within the cored hole.

Like the DODGE Expansion Inserts, the Cone-Spread Insert is used to provide strong, reuseable threads in all plastic parts **after** molding.

AVAILABLE SIZES AND DIMENSIONS				
		A	B	C
SIZE	PART NO.	Installed Length	Outside Diameter	Screw Penetration
#0-80	71011-0	.125	.094	.082
#1-64	71015-01	.156	.109	.111
#1-72	71011-01	.156	.109	.111
#2-56	71015-02	.188	.125	.142
#2-64	71011-02	.188	.125	.142
#3-48	71015-03	.219	.141	.169

How to Order: To order a 2-56 DODGE Cone-Spread Insert by .188 assembled length, order Part No. 71015-02 x .188.

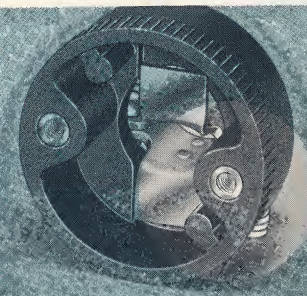


How the DODGE Cone-Spread Principle Works . . .

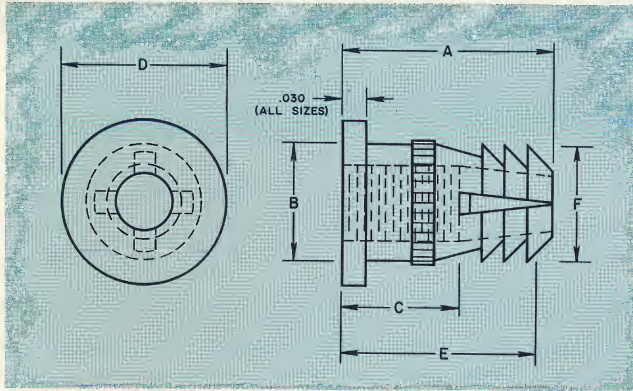
The DODGE Cone-Spread Insert is a one-piece, brass, externally knurled, internally threaded insert joined to a solid cone-shaped base.

1. **After** molding, the Cone-Spread Insert is placed in a hole, cored to a recommended diameter and depth.
2. Downward pressure on the insert, while it rests on its cone on the flat floor of the hole, causes the cone vertex to shear. The cone enters the insert, expanding the knurled body into the wall of the hole, firmly anchoring the insert.

Two DODGE Cone-Spread Inserts are used to provide strong assembly threads in electric plug.



INSERT TYPES



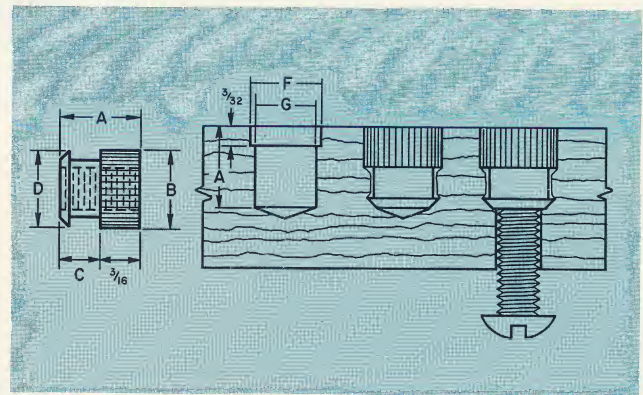
WEDGE INSERT

The Wedge Insert is designed to put strong threads in soft plastics, as well as wood, particle board and other fibrous materials. The DODGE "Expansion Principle" forces the large wedge configurations of the insert body deeply into the wall of the drilled hole, permanently anchoring the insert and giving the installation much greater strength than that found in competitive bushings.

AVAILABLE SIZES AND DIMENSIONS							
		A	B	C	D	E	F
SIZE	PART NO.	In- stalled Length	Body Diam- eter	Threaded Length	Flange Diam- eter	Max. Screw Pene- tration	Hole Size (Drill Size)
6-32	70215-06	.250	.270	.125	.344	.188	"G" (.261)
6-32	70215-06	.313	.270	.178	.344	.250	"G" (.261)
8-32	70215-2	.313	.270	.178	.344	.250	"G" (.261)
10-24	70215-3	.375	.313	.205	.406	.312	"N" (.302)
10-24	70215-3	.500	.313	.240	.406	.437	"N" (.302)
1/4-20	70215-4	.500	.400	.250	.500	.437	25/64 (.391)

How to Order: To order a 10-24 DODGE Wedge Insert by .375 overall length, order Part No. 70215-3 x .375.

DODGE Wedge Expansion Inserts, installed in the side panels of L-shaped secretarial desk, provide blind fasteners for desk assembly.



FLO-LOCK BUSHING

The aluminum Flo-Lock Bushing is an economical threaded fastener designed for use in plastics, wood and other fibrous materials.

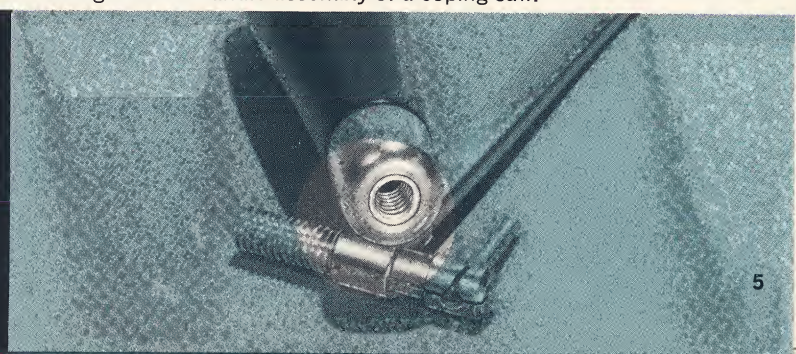
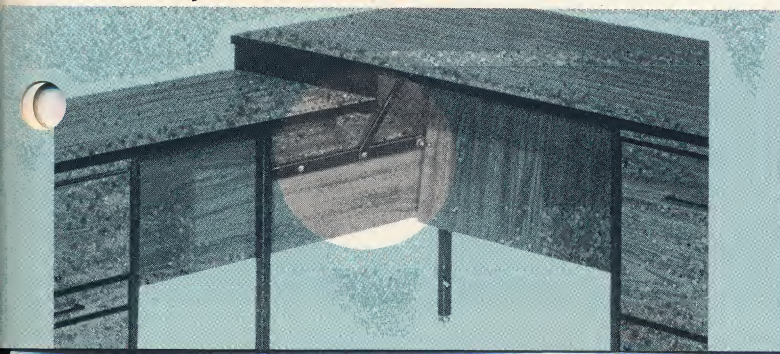
When installed, the Flo-Lock Bushing becomes firmly imbedded as displaced wood "flows" around and behind the dual-action locking feature. High resistance to straight pull is offered by the circumferential wedge located on the lower rim which, after installation, is buried deep within the parent material surrounded by displaced wood fibers. The large axial knurls provide additional anchoring strength and give excellent resistance to rotation.

AVAILABLE SIZES AND DIMENSIONS						DRILL SIZES	
		A	B	C	D	F	G
SIZE	PART NO.	Length	Knurl Diam- eter	Lower Body Length	Fin Diam- eter	Large	Small
4-36	71829-04	.313	.197	.125	.180	.166	.115
4-40	71825-04	.313	.197	.125	.180	.166	.115
6-32	71825-06	.313	.228	.125	.206	.201	.150
8-32	71825-2	.313	.260	.125	.232	.228	.202
10-24	71825-3	.313	.291	.125	.258	.261	.228
1/4-20	71825-4	.375	.354	.188	.318	.323	.282
5/16-18	71825-5	.375	.425	.188	.390	.390	.360
*1/8-27 (pipe)	71828-2	.375	.455	.188	.420	.422	.390
*Combo 1/8-27 4-36	3617	.375	.455	.188	.420	.422	.390


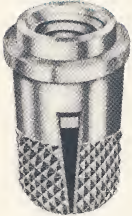
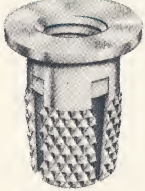



How to Order: To order a 10-24 x 5/16 Flo-Lock Insert, order Part No. 71825-3 x .313.

NOTE: *Both 1/8-27 Inserts listed are furnished with a blind tapped hole; thru tapped hole inserts are special and will be quoted upon request.

The strong aluminum threads of the Flo-Lock Bushing give strength to the handle assembly of a coping saw.



INSTALLATION INFORMATION

INSERT	HOLE SIZE & CONDITION	INSTALLATION METHODS		STRENGTH
		HIGH VOLUME	LOW VOLUME	
STANDARD 	<p>Insert may be installed in either cored or drilled holes, although best results are obtained in the former. Hole diameter .002" greater than nominal body diameter of insert provides adequate strength in general purpose phenolic. See "DODGE Expansion Insert Torque and Tensile Test Data" Bulletin P-110 for recommended hole sizes in various materials.</p> <p>Recommended min. wall thickness surrounding insert, $\frac{2}{3}$ insert body dia., though less is sometimes permissible. Floor of hole must be flat to support insert and retain spreader within insert. Floor thickness should be at least $\frac{1}{2}$ insert length.</p>	<p>DODGE Installation Machine (See Page 7)</p>	<p>DODGE Hand Tool and Semi-Automatic Spring-Loaded Tool</p>	<p>A #6-32 DODGE Standard Expansion Insert installed in general purpose phenolic will withstand 23 in. lbs. torque and 240 lbs. straight pull. This is well above the recommended 9 in. lbs. torque strength of a mild steel #6-32 screw. These strengths were achieved in a drilled hole. Molded holes provide greater assembly strengths. See Bulletin P-110 for Insert Torque and Tensile Test Data.</p>
CLINCH 	<p>Same as for STANDARD Insert.</p> <p>Although the Clinch Insert is supported in the hole by its flange, a floor should be provided in the hole to retain the spreader within the insert. Floor should not be more than .030" below the insert of #6 and #8 sizes, and not more than .020" below the #4 size.</p>	<p>DODGE Installation Machine</p>	<p>DODGE Hand Tool</p> <p>In addition, the DODGE Clinch Semi-automatic tool is available to seat the insert, push the spreader down and clinch the eyelet over a mating part in one operation.</p>	<p>Same as STANDARD Insert</p>
FLANGE 	<p>When flange is used to hold down mating part, thickness of that part must be subtracted from depth of hole to insure retention of the spreader.</p>	<p>DODGE Installation Machine</p>	<p>DODGE Hand Tool and Semi-Automatic Spring-Loaded Tool</p>	<p>Same as STANDARD Insert</p>
CONE-SPREAD 	<p>Hole diameter should be equal to insert body diameter; softer plastics may require smaller hole.</p> <p>Min. wall surrounding insert should be $\frac{2}{3}$ body diameter, although less can be used.</p> <p>Floor thickness should be $\frac{2}{3}$ insert length.</p>	<p>DODGE Installation Machine</p>	<p>Any drive pin that will bear against the top face of the insert, preferably having a short pilot that will fit into the threaded portion.</p>	<p>A #2-56 Cone-Spread Insert installed in general purpose phenolic will withstand 8 in. lbs. torque. A mild steel #2-56 screw will fail at 5 in. lbs., well below the installed strength of the insert.</p>
WEDGE 	<p>Hole diameter should be equal to or slightly smaller than body diameter of insert. Hole may be counterbored to permit flush installation of flange.</p> <p>A floor should be provided not more than .030" below the insert to insure retention of the spreader within the shield.</p>	<p>DODGE Installation Machine</p>	<p>DODGE Hand Tool and Semi-Automatic Spring-Loaded Tool</p>	<p>A #6-32 Wedge Insert, when properly installed, will provide approximate withdrawal loads as follows: white pine, 120 lbs.; particle board, 160 lbs.; maple, 410 lbs., and Cyclocac H, 415 lbs.</p>
FLO-LOCK 	<p>Two specific drill sizes are recommended for each size Flo-Lock insert. A larger hole is drilled to a depth of $\frac{3}{32}$" to enable the dual "Flo-Lock Features" to function properly.</p>	<p>DODGE Installation Machine</p>	<p>Any drive pin that will bear against the top face of the insert, preferably having a short pilot that will fit into the threaded portion.</p>	<p>A Phelps Flo-Lock Bushing, properly installed, will produce tensile strengths approximately double those of straight knurled bushings. A #4-40 Flo-Lock Bushing, installed in the grain end of hardwood will withstand up to 150 lbs. tensile load. A $\frac{1}{4}$-20 Flo-Lock Bushing will withstand over 350 lbs. of direct pull.</p>

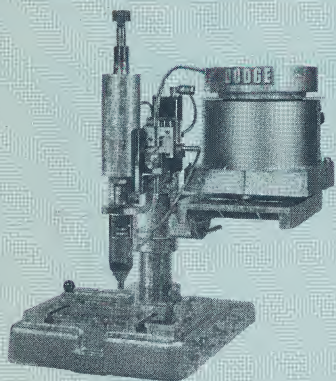
INSTALLATION TOOLING

For DODGE Inserts

AUTOMATIC • SEMI-AUTOMATIC • MANUAL

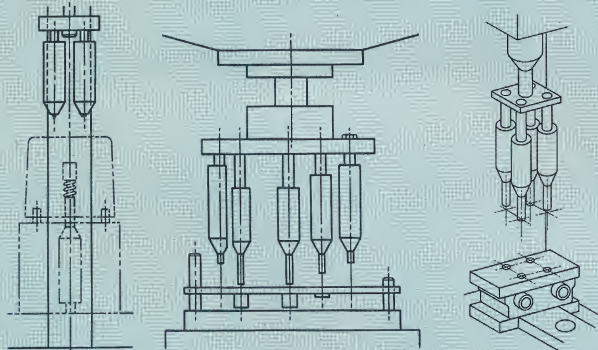
To assure yourself of the fastest installation of DODGE Expansion and Cone-Spread Inserts, you should use DODGE Installation Tooling. While you will obtain excellent quality of installation with DODGE hand and semi-automatic tooling,

you will obtain maximum speed and efficiency when a DODGE Installation Machine is used to install inserts in volume production. Up to 40 single or multiple installations can be made each minute.



Typical DODGE Automatic Installation Machine

Automatic feeding and installation of DODGE Inserts cut labor costs, increase production and assure the highest quality installation of the inserts. This production-proven, all automatic machine places DODGE Inserts into cored or drilled holes and permanently anchors them in one operation.



Multiple spindle tooling for the DODGE Installation Machine has been developed by many original equipment manufacturers and custom molders for the installation of two or more DODGE Inserts simultaneously, as shown above. The DODGE Applications Engineering Department will gladly cooperate with production engineers in the design of special tooling for specific applications of DODGE Inserts.

PURCHASE AND LEASING PLANS

DODGE Automatic Insert Installation Machines may be purchased or leased. Write for Price List D-66 for complete details.

ENGINEERING ASSISTANCE

DODGE representatives, with broad engineering experience in insert technologies, are located in principal industrial centers from coast to coast. These factory-trained experts can provide on-the-spot answers to your questions about strong threads in plastics **after** molding. Of course, the Applications Engineering Department of Phelps Division at Danbury, Connecticut, is available for consultation and will be glad to furnish engineering assistance. The department will also compile test data on your proposed use of DODGE Inserts in any specific material.

DODGE Hand Tool



DODGE Hand Tool may be used to install DODGE Standard, Flange and Wedge Inserts. The tool may be used with hammer or chucked in an arbor press or foot press.

DODGE Semi-Automatic Tools



The Standard Model may be used to install DODGE Standard, Flange and Wedge Inserts. The tool consists essentially of a punch and a spring-loaded sleeve. It **must** be chucked in an arbor press or foot press. It is **not** designed to be driven by a hammer.



The Clinch Insert Model is designed to install and crimp DODGE Clinch Inserts. The tool consists essentially of a punch and a spring-loaded sleeve with a radius section which crimps the eyelet portion of the insert over a terminal, contact strip, switch blade or other component. It **must** be chucked in an arbor press or foot press.

SPECIALS

Standard material for DODGE Expansion and Cone-Spread Inserts is brass; for Phelps Flo-Lock Bushings, aluminum. Cost and delivery of inserts made from materials other than standard will be furnished on request. Inquiries regarding engineering variations of stock inserts are also invited (e.g., special body lengths, flange widths, eyelet heights, etc.).

ORDERING INFORMATION

Ordering and part number call-out instructions are furnished as a footnote to the specifications of each type of insert shown in this catalog.

To order DODGE Hand Tools for Standard, Flange or Wedge Inserts, add the nominal size and length of the insert to the basic part number (e.g., No. 79015-3 x .438). To order other DODGE Installation Tools, add only the nominal size of the insert, regardless of length (e.g., 79035-04).

For price information on all DODGE Inserts, write for Price List D-66.



PHELPS DIVISION

HELI-COIL CORPORATION

SHELTER ROCK LANE, DANBURY, CONNECTICUT 06810

TEL.: (203) 743-7651 (TWX: 203-744-2890)

☐ I have an immediate application which requires strong, durable threads in plastic or a similar material.

Please have your representative contact me as soon as possible.

☐ I am interested in obtaining more information about your DODGE Inserts. Please have your representative contact me the next time he is in my vicinity.

☐ I have a possible future application. I am holding your material for future reference.

☐ I have no immediate use for your products.

Please send ----- samples of
Part Numbers -----

(NAME)

(TITLE)

(COMPANY)

(ADDRESS)

(CITY)

(ZONE)

(STATE)

MY INTEREST IS _____

Postage
Will Be Paid
by
Addressee

No
Postage Stamp
Necessary
If Mailed in the
United States

BUSINESS REPLY MAIL

First Class Permit No. 17

Danbury, Connecticut

HELI-COIL CORPORATION

DANBURY, CONNECTICUT



October 15, 1966

Price List and Discount Schedule
for Manufacturers**DODGE[®] EXPANSION INSERTS****Standard Expansion Insert**

SIZE	PART NO.	NET PRICES PER THOUSAND						
		Min. to 999	1M to 4,999	5M to 24,999	25M to 49,999	50M to 99,999	100M to 499,999	500M & UP
4-40	70015-04 x .250	18.20	14.50	12.20	11.30	10.80	10.10	9.30
5-40	70015-05 x .313	19.50	15.40	13.10	12.20	11.50	10.90	9.90
6-32	70015-06 x .313	19.50	15.40	13.10	12.20	11.50	10.90	9.90
6-32	70015-06 x .375	21.50	17.00	14.40	13.40	12.60	12.00	10.90
8-32	70015-2 x .313	22.20	17.60	14.80	13.80	13.10	12.30	11.20
8-32	70015-2 x .375	24.20	19.10	16.10	15.00	14.20	13.40	12.20
10-24	70015-3 x .375	25.30	20.00	16.80	15.70	14.90	14.00	12.70
10-24	70015-3 x .438	27.40	21.70	18.40	17.10	16.20	15.20	13.90
10-32	70011-3 x .313	23.10	18.20	15.40	14.40	13.60	12.80	11.70
10-32	70011-3 x .375	25.30	20.00	16.80	15.70	14.90	14.00	12.70
10-32	70011-3 x .438	27.40	21.70	18.40	17.10	16.20	15.20	13.93
1/4-20	70015-4 x .500	41.70	32.90	27.70	25.90	24.50	23.20	21.10

Flange Insert

SIZE	PART NO.	NET PRICES PER THOUSAND						
		Min. to 999	1M to 4,999	5M to 24,999	25M to 49,999	50M to 99,999	100M to 499,999	500M & UP
4-40	70315-04 x .219	20.00	15.90	13.40	12.40	11.80	11.10	10.10
6-32	70315-06 x .281	23.60	18.70	15.80	14.70	13.90	13.20	12.00
8-32	70315-2 x .281	24.60	19.40	16.40	15.30	14.50	13.70	12.50
10-24	70315-3 x .313	29.70	23.50	19.90	18.50	17.50	16.50	15.00
10-32	70311-3 x .313	29.70	23.50	19.90	18.50	17.50	16.50	15.00
1/4-20	70315-4 x .438	48.60	38.40	32.40	30.20	28.60	27.00	24.60

Clinch Insert

SIZE	PART NO.	NET PRICES PER THOUSAND						
		Min. to 999	1M to 4,999	5M to 24,999	25M to 49,999	50M to 99,999	100M to 499,999	500M & UP
4-40	70515-04 x .040 x .250	21.30	16.80	14.20	13.30	12.50	11.90	10.80
4-40	70515-04 x .064 x .226	21.30	16.80	14.20	13.30	12.50	11.90	10.80
6-32	70515-06 x .040 x .313	25.50	20.20	17.10	15.90	15.00	14.10	12.80
6-32	70515-06 x .064 x .289	25.50	20.20	17.10	15.90	15.00	14.10	12.80
8-32	70515-2 x .040 x .375	26.70	21.10	17.80	16.60	15.70	14.80	13.50
8-32	70515-2 x .064 x .351	26.70	21.10	17.80	16.60	15.70	14.80	13.50

Continued on reverse side



PHELPS DIVISION
HELI-COIL CORPORATION
SHELTER ROCK LANE, DANBURY, CONNECTICUT 06810

TELEPHONE: (203) 743-7651

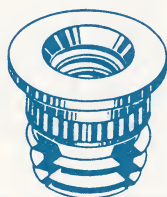
TWX: 203-744-2890

Cone-Spread Insert



SIZE	PART NO.	NET PRICES PER THOUSAND						
		Min. to 999	1M to 4,999	5M to 24,999	25M to 49,999	50M to 99,999	100M to 499,999	500M & UP
0-80	71011-0 x .125	15.10	11.90	10.80	9.70	9.20	8.60	8.10
1-64	71015-01 x .156	15.10	11.90	10.80	9.70	9.20	8.60	8.10
1-72	71011-01 x .156	15.10	11.90	10.80	9.70	9.20	8.60	8.10
2-56	71015-02 x .188	15.10	11.90	10.80	9.70	9.20	8.60	8.10
2-64	71011-02 x .188	15.10	11.90	10.80	9.70	9.20	8.60	8.10
3-48	71015-03 x .219	15.10	11.90	10.80	9.70	9.20	8.60	8.10

Wedge Insert



SIZE	PART NO.	NET PRICES PER THOUSAND						
		Min. to 999	1M to 4,999	5M to 24,999	25M to 49,999	50M to 99,999	100M to 499,999	500M & UP
6-32	70215-06 x .250	31.50	24.90	21.10	19.60	18.60	17.50	16.00
6-32	70215-06 x .313	33.80	26.70	22.60	21.10	19.90	18.80	17.10
8-32	70215-2 x .313	33.80	26.70	22.60	21.10	19.90	18.80	17.10
10-24	70215-3 x .375	39.50	31.20	26.30	24.60	23.30	22.00	20.00
10-24	70215-3 x .500	42.50	33.70	28.40	26.50	25.00	23.60	21.50
1/4-20	70215-4 x .500	55.80	44.20	39.00	36.40	34.40	32.50	30.30

Phelps Flo-Lock Bushing



SIZE	PART NO.	NET PRICES PER THOUSAND						
		Min. to 999	1M to 4,999	5M to 24,999	25M to 49,999	50M to 99,999	100M to 499,999	500M & UP
4-36	71829-04 x .313	9.10	7.20	6.40	5.90	5.60	5.30	5.20
4-40	71825-04 x .313	10.10	8.10	7.10	6.70	6.30	5.90	5.80
6-32	71825-06 x .313	10.90	8.60	7.70	7.10	6.70	6.40	6.30
8-32	71825-2 x .313	11.80	9.30	8.20	7.70	7.20	6.90	6.70
10-24	71825-3 x .313	12.80	10.10	9.00	8.30	7.90	7.40	7.30
1/4-20	71825-4 x .375	15.20	12.00	10.60	9.90	9.40	8.80	8.60
5/16-18	71825-5 x .375	18.50	14.60	12.80	12.00	11.30	10.70	10.50
1/8-27 (pipe)	71828-2 x .375	20.30	16.10	14.10	13.30	12.50	11.80	11.50
1/8-27 & 4-36	3617	27.60	21.90	19.30	18.00	17.10	16.10	15.80

- TERMS 1/2% TEN DAYS, NET THIRTY DAYS, F.O.B. DANBURY, CONN.
- MINIMUM ORDER - \$5.00 PER ITEM



PHELPS DIVISION
HELI-COIL CORPORATION
SHELTER ROCK LANE, DANBURY, CONNECTICUT 06810

TELEPHONE: (203) 743-7651

TWX: 203-744-2890

Manual and Semi-Automatic Installation Tools

(see next page for automatic installation machines)

FOR **DODGE** EXPANSION INSERTS

DODGE HAND TOOL

To anchor *Dodge* Standard Inserts
Dodge Flange Inserts and
Dodge Wedge Inserts

Size of Insert	Tool No.	Price Each
4-40	79015-04	\$ 2.00
5-40	79015-05	2.00
6-32	79015-06	2.00
8-32	79015-2	2.00
10-24	79015-3	2.00
10-32	79015-3	2.00
1/4-20	79015-4	2.00

Please give length
of insert as suffix
after tool number

DODGE SEMI-AUTOMATIC TOOL

To seat and anchor *Dodge* Standard Inserts
Dodge Flange Inserts
Dodge Wedge Inserts

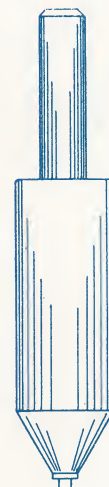
Size of Insert	Tool Number	Price Each
4-40	79005-04	\$ 9.00
5-40	79005-05	9.00
6-32	79005-06	9.00
8-32	79005-2	9.00
10-24	79005-3	9.00
10-32	79005-3	9.00
1/4-20	79005-4	9.00

DODGE CLINCH INSERT SEMI-AUTOMATIC TOOL

To seat, anchor and crimp *Dodge* Clinch Inserts only.

Size of Insert	Tool Number	Price Each
4-40	79035-04	9.00
6-32	79035-06	9.00
8-32	79035-2	9.00

SEE NEXT PAGE FOR AUTOMATIC INSTALLATION MACHINES



PHELPS DIVISION
 HELI-COIL CORPORATION

SHELTER ROCK LANE, DANBURY, CONNECTICUT 06810

TELEPHONE: (203) 743-7651

TWX: 203-744-2890